											- n-	
Work Ord Wednesday, Sep												Page
Item ID: Revision ID: Item Name:	D3660-1 CUFF		A	Accept				s s	Setup	Start Stop		
Start Date: Required Date: Reference:	9/22/2010 9/29/2010	Start Qty: 10.00 Req'd Qty: 10.00	1 15 1 15 1 15 1 15 1 15 1 15 1 15 1 1		Cust Item I Customer:	D:						
Approvals:	Process Plan	7	Date:	Tooling: SPC (Y/N):		nte:		ł	Run	Start Stop		
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr								<del></del>	-11	
D3660	Rev	В										
100 Bandsaw Jeaspa Bandsaw		BAND SAW  Memo  Cut blank 7	.300 " long	0.00	el 10.10	5		10				
Doosan Lathe		DOOSAN LATHE  Memo  1-Turn as pe FOLIO REV DWG REV: 2-Deburr as		0.00 0.00 exf	? 10·10·	5		10		<i>-</i>		

120

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

0.00

W/O:			W	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Wgr	
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQA</b> :		_ Date: _	
		esolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)			•
DATE	STEP	Description of NC Corrective Action			on B	Verificat	tion	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
<del>"                                    </del>									
			,		·				
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#### Work Order ID 62225

Wednesday, September 22, 2010 3:14:54 PM



Page 2

Item ID:

Revision ID:

D3660-1

Item Name: CUFF

Start Date:

9/22/2010

QC:

**Start Oty: 10.00** Req'd Oty: 10.00 **Required Date: 9/29/2010** 

Accept



Setup Start



Start

Stop



Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_

Date:

Tooling: SPC (Y/N):

Set Up/

**Cust Item ID:** 

**Customer:** 

Tool ID

Date:

Date:

Tool # Plan

Accept Qty Code

Reject Otv

Run

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

**Run Hours** 

0.00

0.00

10/10/06

140

HandFinish

Hand Finishing

Memo

Chemical Conversion Coat per OSI005 4.1

0.00

0.00 BR 10-10-7

150

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

	WORK ORDER CHANGES											
STEP	PRC	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector				
							Frod Mgr					
:	PAR #:	Fault Cate	egory:	NCR: Yes	No DG	A:	Date:					
R	esolution:	Dispositi	on:	_ QA: N/C C	Date: _	· · · · · · · · · · · · · · · · · · ·						
	\	WORK ORE	DER NON-CONFORMA	NCE (NCF	?)	·						
CTED	Description of NC	Description of NC Corrective Action			Verif	ication	Approval	Approval				
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		k Sec		Chief Eng	QC Inspector				
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		:PAR #: Resolution:	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORMA  STEP Description of NC Section A Corrective Action Section Initial Action Description	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C CI  WORK ORDER NON-CONFORMANCE (NCF  STEP Description of NC Section A Chief Eng Action Description Chief Eng Chief	STEP PAR #: Fault Category: NCR: Yes No DC Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Date:  PAR #: Fault Category: NCR: Yes No DQA: Date:  Resolution: Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Corrective Action Section B Section Chief Eng Chief				

### Work Order ID 62225

Wednesday, September 22, 2010 3:14:54 PM



Page 3

Item ID:

D3660-1

Accept



Setup Start



**Revision ID:** 

Item Name:

**CUFF** 

**Start Date:** 9/22/2010 **Required Date:** 9/29/2010

**Start Qty: 10.00** 

Req'd Qty: 10.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Memo

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run Start

Stop

Stop

Sequence ID/ **Work Center ID** 

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00 0.00 **Tool ID** 

Tool # Plan Code

Accept Qty

Reject Reject **Qty** Number

Insp. Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/12/8) MF 10-12

W/O:			M	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty Approx Chief En	g/ Approvai
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							,	
Part No:	·	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date	):
	Resolution:			ion:	_ QA: N/C Cld	sed:	Date	):
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCR	)		
DATE	STEP	Description of NC			ion B	Verificat	tion Appro	val Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		
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### **Picklist Print**

Wednesday, September 22, 2010 3:14:58 PM

Work Order ID: 62225

Parent Item: D3660-1

Parent Item Name: CUFF



Start Date: 9/22/2010

Required Date: 9/29/2010

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP rev A new issue 07.09.19 EC verified by:JLM IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-180		Manufactured	No			100	Each	8.0000	0.056	0.589474	10.10	· · ·	

Crosstube Extrusion

Location

Loc Qty

Loc Code

\_\_\_\_

467.79

LG

i

6.083

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector				
7.97								Prod Mgr					
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQA</b>	\:	Date: _					
	R	esolution:	Dispositi	on:	QA: N/C CI	osed:	· · · · · · · · · · · · · · · · · · ·	Date: _					
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	()							
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector				
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DART AEROSPACE LTD	Work Order:	42225
Description: Cuff	Part Number:	D3660-1
Inspection Dwg: D3660 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST										
X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
3.950	+/-0.010	3.450								
3.075	+/-0.010	3.075		_						
2.500	+/-0.010	2.500	-/-			•				
1.700	+/-0.010	1-700								
0.800	+/-0.010	, 800								
0.438	+/-0.010	. 438								
Ø0.128	+0.005/-0.001	,128								
Ø0.230 x 100°	+/-0.010 x 0.5°	,233×10	o° /							
Ø0.386	+0.005/-0.000	. 371								
Ø2.990	+0.005/-0.000	2.992								
Ø2.695	+0.005/-0.000	2.697								
2.050	+/-0.005	2.048								
1										

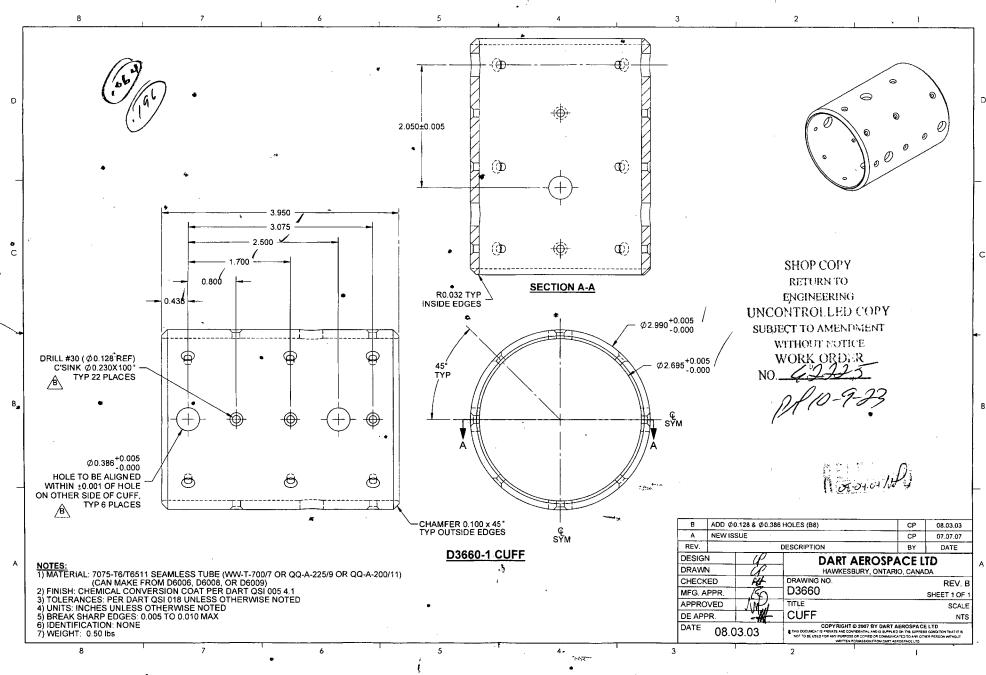
Measured by:	Audited by:	D	Prototype Approval:	N/A
Date: 10.10.5	Date:	10/10/06	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	08.05.12	New Issue	KJ/DD ckt/ A
			7)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		· · · · · · · · · · · · · · · · · · ·								

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Approval			
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	С	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:				NCR: Yes No DQA: Date:					
	R	esolution:	Disposition	QA: N/C Closed: Date:					
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (N	CR)	-deck		
DATE	0750	Description of NC Section A			ion B		Verification	Approval	Approval
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